

HiFill® TPX-PA6/6-97002 A1 UV LE

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Low Extractables • UV Resistant
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.18E+6	psi	ASTM D638
Tensile Strength (Yield)	22400	psi	ASTM D638
Tensile Strength (Break)	22300	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.8	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

Notes

¹ Typical properties: these are not to be construed as specifications.

